

Date: Wednesday, 9/20/2006 3:22:34 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : OH-58 FWD X-TUBE ASSEMBLY
 Job Number : 28660
 Estimate Number : 12526
 P.O. Number : N/A Part Number : D058676101
 This Issue : 9/20/2006 S.O. No. : N/A Drawing Number : D058-676-141 REV A2
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : LANDING GEAR Drawing Revision : A2
 Previous Run : 28468 Material : N/A
 Due Date : 10/10/2006 Qty: 1 Um: Each
 Written By : [Signature]
 Checked & Approved By : [Signature]
 Comment : Est Rev:E 06.09.11 Reformat IEC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D058-676-141CHG001

-101

KS 06.09.21

2.0 D6001105 Crosstube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D6001-105 Crosstube 23965

SC 06.09.20 1

3.0 MORI SEIKI MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand & install plugs on both ends as per Folio FA085

2-Turn first side as per Folio FA085

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D058-676-141.

SC/M 06.09.20

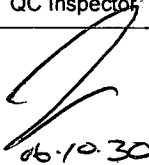
4.0 QC1 INSPECT ALL DIM TO DIM SHEET




Comment: INSPECT ALL DIM TO DIM SHEET

SC 06.09.20 1

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | | |
|----------|------|------------------------------|----|------|-----|-------------------------------------|---|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| 06/10/30 | 1.0 | -101 not -201. param. change | | | | |  06-10-30 | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|----------|------|--|-----------------------------|---|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 06/09/21 | 3 | Tube vibrated on 1 side, section was polished, dim. 2.183 is 2.180. Is tube acceptable. | | wrong W/O  | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OH-58 FWD X-TUBE ASSEMBLY

Job Number: 28660

Part Number: D058676101

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA085

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D058-676-141. *36 06-09-20 1*

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

36 06-09-20 1

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

3.6 0610-01-25 1

8.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE

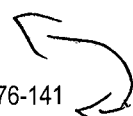


Comment: MORI SEIKI CNC LATHE LARGE

1-Polish entire outside surface of crosstube ~~*Done at Seq # 13.0~~ *13.0 PM 06-9-26 1*

2-Remove sand and plugs

3-Scribe part # and batch # using vibrating stylus as per Dwg D058-676-141
Inside of Cuff (Do not engrave on outside of tube)



36 06-09-20 1

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

0.0 06-09-26 1

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DP 6-9-27

11.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D058-676-241 using CNC bender program OH58-fw and Folio FT014

DP 6-9-27

Wrong Filed 11/06-08-27

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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QA: N/C Closed: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OH-58 FWD X-TUBE ASSEMBLY

Job Number: 28660

Part Number: D058676101

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC6

DIMENSIONAL CHECK



Joe 10.03 ①



Comment: Inspect dimensions and work To Current Step

13.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube as per Dwg D058-676-141 using drill Jig DT8541 & DT8542

2-Ream hole to finish size in tube as per Dwg D058-676-141 using drill Jig DT8541 & DT8542. Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes.

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D058-676-141

RT 06 10 05
DP 6-10-3

14.0

HAND FINISHING 1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FL 06 10 05 ①

15.0

QC5

INSPECT WORK TO CURRENT STEP



Joe 10.05



Comment: INSPECT WORK TO CURRENT STEP

16.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 0380

Issue P/O: *2186*

LPI as per ASTM 1417 Level 2

Attach copy of NDT results to work order

C 206/10/05 ①

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage Ensure copy of NDT results attached to work order.

QB 06/10/10 ①

18.0

QC6

DIMENSIONAL CHECK



Joe 10.12 ①



Comment: Inspect for damage & ensure results are as per Dwg D058-676-241

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Process Sheet

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Drawing Name: OH-58 FWD X-TUBE ASSEMBLY

Job Number: 28660

Part Number: D058676101

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

FC/M

06 10 25 (1)

2-Paint outside crosstube with White Imron as per QSI 005 4.2

M

06 10 25

(1)

20.0

QC14

Inspect Spray Paint



Comment: Inspect Spray Paint

Then, Wrap in plastic bag to protect from scratches

Sub 10-26 (1)

21.0

D2856400

Abrasion Strip



Comment: Qty.: 0.5800 f(s)/Unit Total : 0.5800 f(s)

Pick:

Qty Part number

Description

Batch

2 D2856-400-694 Abrasion Strip

B28258

IT 06-10-30

22.0

D28911

Support 2.25 dia



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number

Description

Batch

2 D2891-1

Support B28792

IT 06-10-30

23.0

MS2192020

Clamp (per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number

Description

Batch

4 MS21920-20

Clamp M162440

IT 06-10-30

24.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips as per QSI 035 using DT8579

2-Install supports and clamps as per Dwg D058-676-141. Torque clamps to 80-100 in lb.

3 IT 06-10-30 (1)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Drawing Name: OH-58 FWD X-TUBE ASSEMBLY

Job Number: 28660

Part Number: D058676101

Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

For 10-30-06
1006/10/30 (1)

26.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

27.0

AN532A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part number

Description Batch

✓ 4 AN5-32A

Bolt

M102238

28.0

AN960JD516

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part number

Description Batch

✓ 8 AN960JD516

Washer

M102328

29.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part number

Description Batch

✓ 4 MS21042L5

Nut (or -5)

M101648

P04/10/31 (1)

30.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

B06/10/31 (1)

31.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D058-676-101

Location:

Dev B

P04/10/31 (1)

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: RB Date: 06/15/13
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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Drawing Name: OH-58 FWD X-TUBE ASSEMBLY

Job Number: 28660

Part Number: D058676101

Job Number:



Seq. #:

Machine Or Operation:

Description :

32.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Handwritten: 06/18/31 (1)

Job Completion



Handwritten: U 26-031

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries



| | | | |
|---------------------|-----------------------|---|------------------------|
| DESIGN <i>CP</i> | DRAWN BY <i>CP</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>#</i> | APPROVED <i>#</i> | DRAWING NO. D058-676-141 | REV. A SHEET 1 OF 3 |
| DATE 00.11.17 | | TITLE CROSSTUBE ASS'Y (OH-58 HIGH FWD) NTS | |
| A | 00.11.17 | NEW ISSUE | |

| Qty | Part Number | Description |
|-----|---------------|-------------------------------------|
| X | D058-676-141 | CROSSTUBE ASSEMBLY (OH-58 HIGH FWD) |
| 1 | D6001-105 | CROSSTUBE |
| 2 | D2856-400-694 | ABRASION STRIP |
| 2 | D2891-1 | SUPPORT |
| 4 | MS21920-20 | CLAMP |

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6001-105
FINISHED LENGTH = 103.03±0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-400-694 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2891-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) SEAL EDGES OF SUPPORTS AND ABRASION STRIP USING SIKAFLEX-241/291 SEALANT.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 28660

RELEASED
00.11.24 *#*

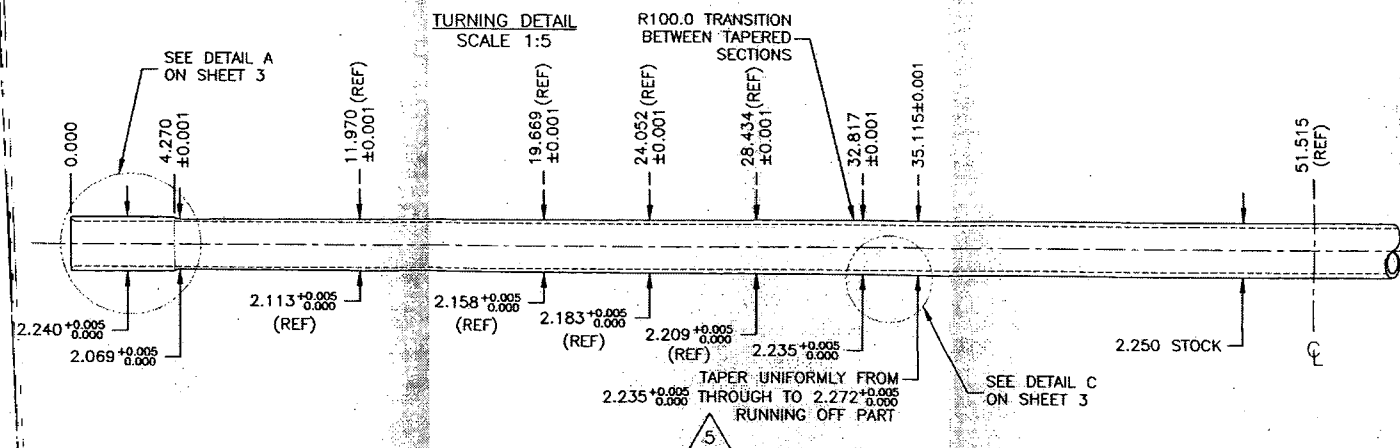
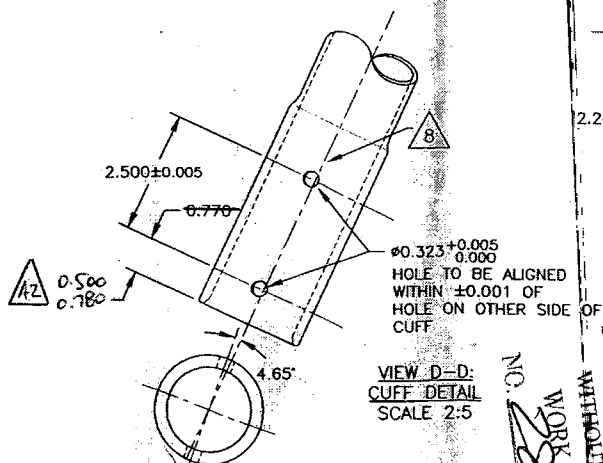
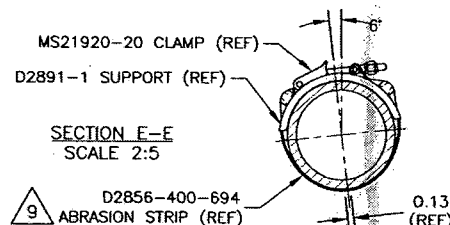
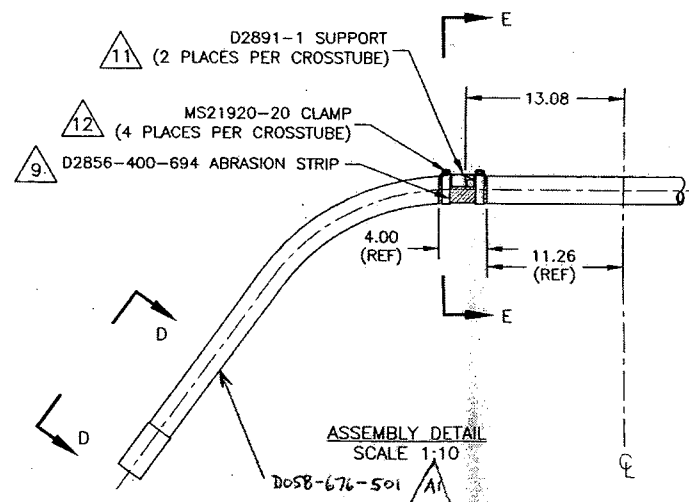
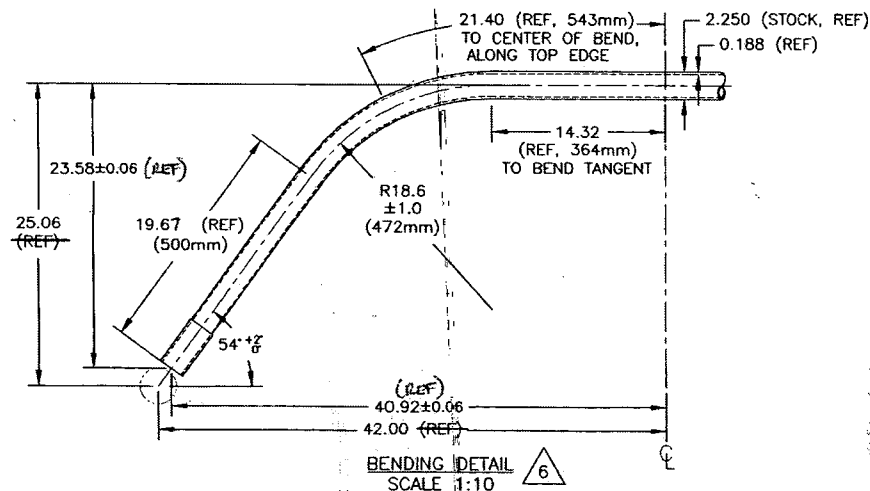
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|----|----------|--------------------------|-------------|
| A2 | 01.07.16 | UPDATE DIM TO FIRST HOLE | <i># CP</i> |
| A1 | 01.03.07 | ADD D058-676-501 P/N | <i># CP</i> |

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RELEASED

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| | | DATE | 00.11.17 | | | D058-676-141 | SHEET 2 OF 3 |
| | | | | | | TITLE | SCALE |
| | | | | | | CROSSTUBE ASSEMBLY (04-57 HIGH FWD) | 1:10 |

NO. 28660

WORK ORDER

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RETURN TO

ENGINEERING

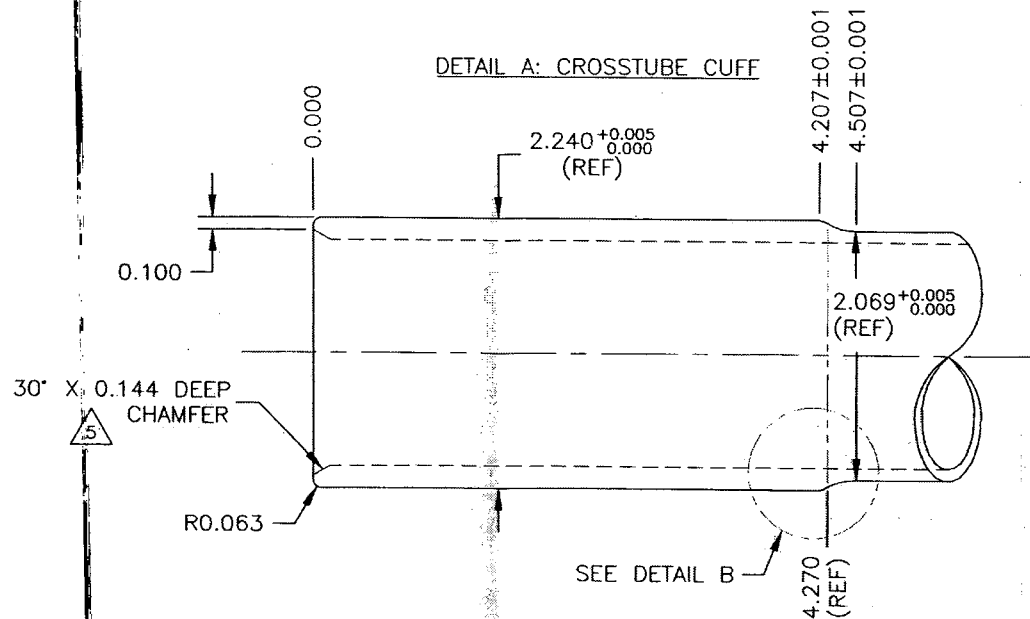
UNCONTROLLED COPY

SUBJECT TO AMENDMENT

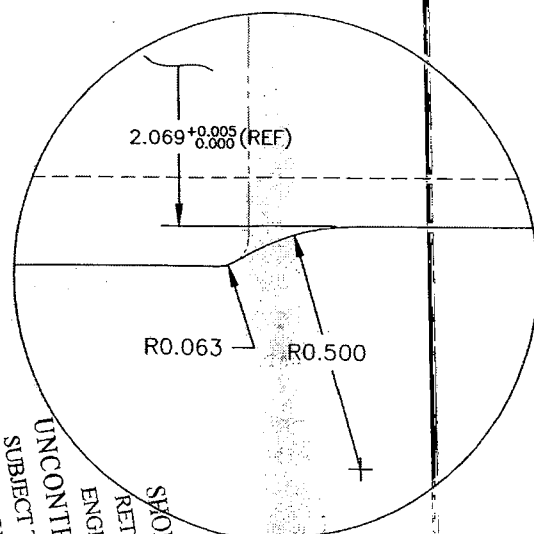
WITHOUT NOTICE

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00.11.24

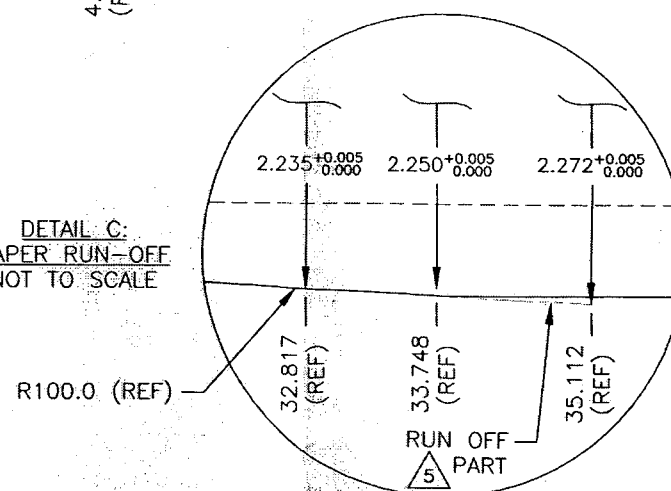
DETAIL A: CROSSTUBE CUFF



DETAIL B:
CUFF TRANSITION
SCALE 4:1



DETAIL C:
TAPER RUN-OFF
NOT TO SCALE



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DESIGN
CP
CHECKED

DATE
00.11.17

DRAWN BY
CP
APPROVED
#

DART DART AEROSPACE LTD.
WARRICKSURY, OXFORD, CANADA
DRAWING NO.
D058-676-141
TITLE
CROSSTUBE ASSEMBLY (CH-53 HIGH FWP)
REV. A
SHEET 3 OF 3
SCALE
1:1

NO. 28660
WORK ORDER
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

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|--|--|----------------------------------|
| DART AEROSPACE LTD | | Work Order: 28660 |
| Description: X-Tube | | Part Number: DUS8-676-141 |
| Inspection Dwg: DUS8-676-141 Rev: A | | Page 1 of 1 |

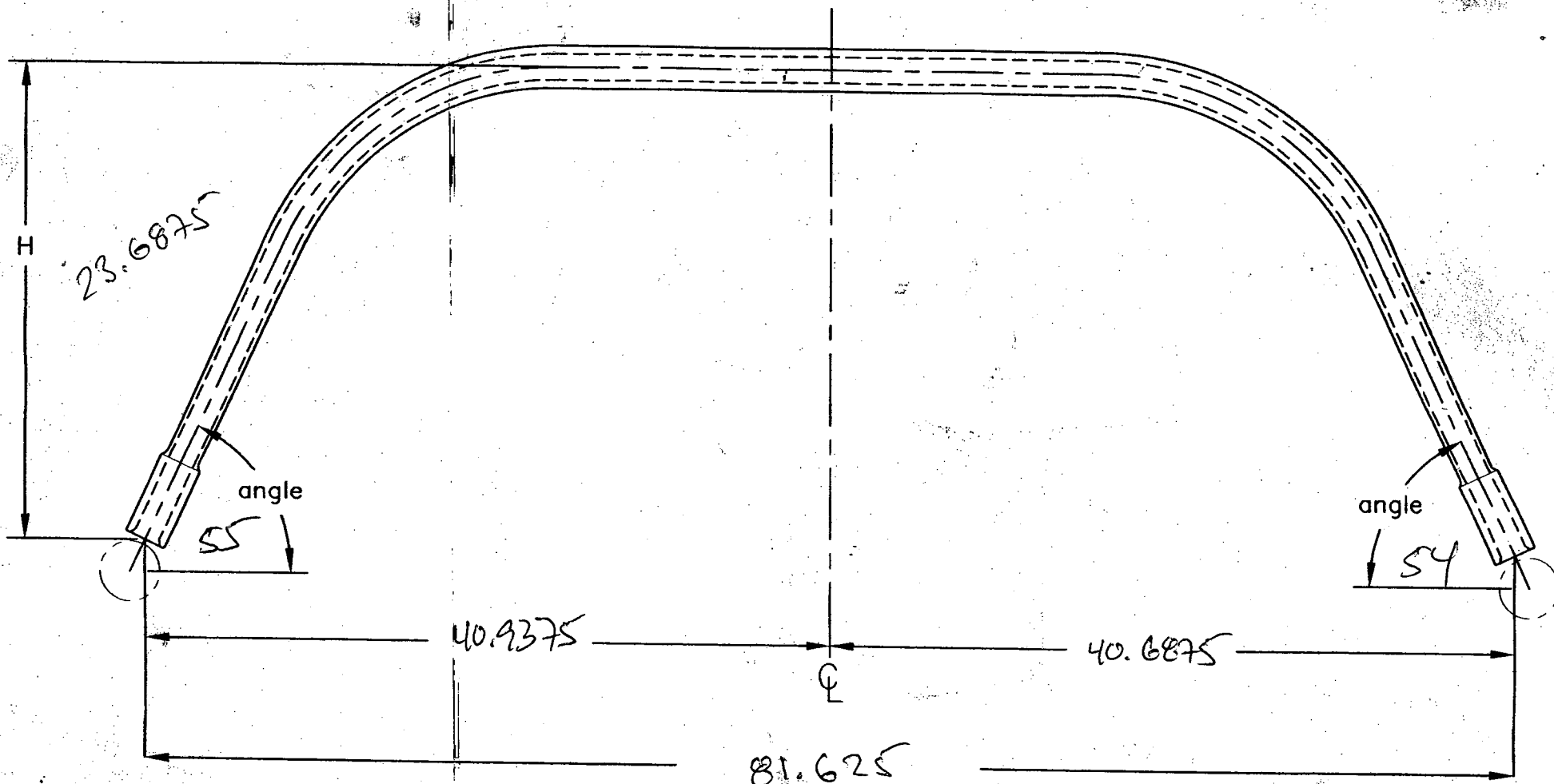
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------------|------------------|--------|--------|----------------------|----------|
| 2.240 | $\pm .005 / - .000$ | 2.242 | ✓ | | | |
| 2.069 | " | 2.073 | ✓ | | | |
| 2.113 | " | 2.117 | ✓ | | | |
| 2.158 | " | 2.161 | ✓ | | | |
| 2.183 | " | 2.187 | ✓ | | | |
| 2.209 | " | 2.213 | ✓ | | | |
| 2.235 | " | 2.238 | ✓ | | | |
| .100 | $\pm .010$ | .100 | ✓ | | | |
| 4.207 | $\pm .030$ | 4.207 | ✓ | | | |
| 2.240 | $\pm .005 / - .000$ | 2.242 | ✓ | | | |
| 2.069 | " | 2.073 | ✓ | | | |
| 2.113 | " | 2.118 | ✓ | | | |
| 2.158 | " | 2.162 | ✓ | | | |
| 2.183 | " | 2.187 | ✓ | | | |
| 2.209 | " | 2.212 | ✓ | | | |
| 2.235 | " | 2.238 | ✓ | | | |
| .100 | $\pm .010$ | .100 | ✓ | | | |
| 4.207 | $\pm .03$ | 4.207 | ✓ | | | |
| 103.03 | $\pm .02$ | 103.03 | ✓ | | | |
| | | | | | | |
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| | | |
|---------------------------------|-------------------------|----------------------------|
| Measured by: [Signature] | Audited by: J.L. | Prototype Approval: |
| Date: 06.09.20 | Date: 06/09/21 | Date: |

| Rev | Date | Change | Revised by | Approved |
|-----|------|-----------|------------|----------|
| A | | New Issue | KJ/JLM | |



DATE: 06-10-03

DESCRIPTION: 058-676-101

BATCH NO: B28660

DRAWING: 058-676-141 Rev-A

H: 23.58 } $\pm .060$

1/2 SPAN: 40.92

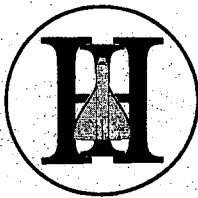
TOTAL SPAN: 81.84

ANGLE: 54⁺²-0

.095 under tol. Rits sig A1

[Signature]
25/10

[Signature]



HeathAir

INTERNATIONAL (1991) INC.

681 Ave. Lepine, Dorval, Québec H9P 1G3
Tél.: (514) 636-1000 • Fax: (514) 636-0031

W.O. N° 34996

A.M.O. Number: 46/90

NON-DESTRUCTIVE TESTING REPORT

AIRCRAFT / COMPONENT INFORMATION

REGISTRATION:

MODEL/TYPE:

SERIAL NUMBER:

TOTAL HR/LDG:

OPERATED BY:

BASED AT:

INSPECTION REQUIREMENTS

Carry out FPI of six (6) cross tubes (external surface) as per ASTM E-1417-05 and the Dart QSI 038, Section 4.1.1 (on file at client) - parts delivered to HeathAir.

Qty. (4) P/N D058-676-101 S/N's B28676, B28675, B28660 & B28467

Qty. (2) P/N D058-676-201 S/N's B28768 & B28765

☐ RADIOGRAPHY

☐ ULTRASONIC

☒ PENETRANT

☐ MAGNETIC PARTICLE

☐ EDDY CURRENT

INSPECTION REPORT

Fluorescent penetrant inspection was performed in accordance with the above requirements on six (6) cross tubes.

Note: A Level 3 penetrant was substituted for the requested Level 2 (3 is more sensitive)

Ardrox 970P25E Batch #04B503.

Six (6) cross tubes PASSED inspection.

THE MAINTENANCE DESCRIBED ABOVE HAS BEEN PERFORMED IN ACCORDANCE WITH
THE APPLICABLE STANDARDS OF AIRWORTHINESS

INSPECTED BY: 

DATE October 6, 2006

INSPECTION STAMP(S) Not Required

CUSTOMER INFORMATION

CUSTOMER: Dart Aerospace

P.O. NUMBER

00002186

ADDRESS:

CONTACT NAME:

| | | |
|-----------------|---|-----|
| LABOUR | @ | \$ |
| MATERIALS | @ | |
| TRAVEL EXPENSES | @ | GST |
| HOTEL EXPENSES | @ | PST |

INVOICE NO.

TOTAL \$